

Work Order ID 129566

129566

Page 2

February-17-15 7:34:00 AM

Item ID: D4720-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Spacer

Start Date: 2/17/15

Start Qty: 400.00

400

Cust Item ID:

Required Date: 2/27/15

Req'd Qty: 400.00

400

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

2L15-2-24

130

Outsource process - Heat Treat

0.00

130

Outsource1

Memo

0.00

Outsource process - Heat Treat

HEAT TREAT AS PER DWG D4720

P/O. 27531

CY 15/02/24 420

140

Receive & Inspect for Damage & Mat'l Certs

0.00

140

Packaging

Memo

0.00

Packaging

4/20 X 8015-03-10

Work Order ID 129566

129566

Page 3

February-17-15 7:34:00 AM

Item ID: D4720-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Spacer
 Start Date: 2/17/15 Start Qty: 400.00 *400* Cust Item ID:
 Required Date: 2/27/15 Req'd Qty: 400.00 *400* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC6- Inspect dimensions to drawing	0.00							9-89
150									
QC	Memo	0.00							
Quality Control									
190	Identify as per dwg & Stock Location: <u>L/O</u>	0.00							
190									
Packaging	Memo	0.00							
Packaging	***STOCK IN SKIDTUBE CELL***								
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

420 15-3-10 MLJ 15-03-11

Picklist Print

Page 1

February-17-15 7:33:59 AM

Work Order ID: 129566

129566

Parent Item: D4720-1

D4720-1

Parent Item Name: Spacer

Start Date: 2/17/15

Required Date: 2/27/15

Start Qty: 400.00

Required Qty: 400.00

Comments: IPP REV:A 12.11.20 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.375W.058		Purchased	No			100	f	202.5400	0.265	112			
M6061T6T0 375W 058										**		15/02/23	DAS 40 9-89
6061-T6 RD Tube .375 x.058W													

Location

Loc Qty

Loc Code

MAT013

202.54

m128833

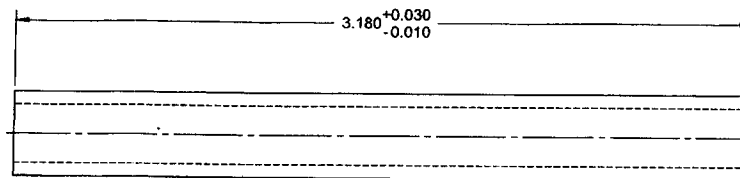
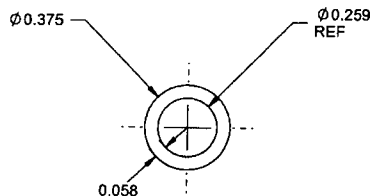
45.16



m130510

157.38

120



D4720-1 SPACER

Wlo 129566

RELEASE
2012-11-16

NOTES:

- 1) MATERIAL: 6061-T4/T42 ALUMINUM TUBING PER WW-T-700/6, AMS 4081, OR ASTM B210 / B221 / B241
REF DART SPEC M6061T4T0.375V.058
OR
6061-T6/T62 ALUMINUM TUBING PER WW-T-700/6, QQ-A-225/8, AMS 4080 / 4082, OR ASTM B210 / B221 / B241
REF DART SPEC M6061T6T0.375V.58
HEAT TREAT TO -T4/T42 CONDITION. MIN UTS = 30 KSI (60 HREW MIN)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

A	NEW ISSUE	RP	12.09.10
REV.	DESCRIPTION	BY	DATE
DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4720	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		SPACER	NTS
DATE	12.09.10	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27531**

Purchase Order Date 2/23/2015

PO Print Date 2/24/2015

Page Number 1 of 2

Order From :

VC-MET004

METCOR INC.
560 BOUL. ARTHUR SAUVE
SAINT-EUSTACHE, QC J7R 5A8
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 450 473 1884

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	129565	D4202-1 SPACER	3/6/2015 Yes 3/6/2015		415.00	\$1.32	\$547.64
	HEAT TREAT TO T4/T42 CONDITION MIN. UTS=30 KSI (60 HREW MIN) NOTE: DETAIL C OF C REQUIRED PART ARE MADE FROM 6061-T6 MATERIAL						
						Line Total:	\$547.64
3	129566	D4720-1 SPACER	3/6/2015 Yes 3/6/2015		420.00 ✓	\$131.96	\$55,424.25
	HEAT TREAT TO T4/T42 CONDITION MIN. UTS=30 KSI (60 HREW MIN) NOTE: DETAIL C OF C REQUIRED PART ARE MADE FROM 6061-T6 MATERIAL						
						Line Total:	\$55,424.25

SP15-03-10

Note:

2/24/2015

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
203060	1	88998

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À / Shipped To

DART AEROSPACE

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
27531		AL-6061	2015/2/24	client

QUANTITÉ Quantity	No. PIÈCE / Part No.	NOM DE LA PIÈCE / Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight
----------------------	-------------------------	--------------------------------	---	-----------------

835 D4202-1

22,

(415) D4202-1 SPACER

129565

(420) D4720-1 129566

2 BOITE DE CARTON

515-03-10

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
BOITE DE CARTON	2	

CERTIFICAT

EMPAQUETAGE Packing	
------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 835

POIDS EXPÉDIÉ / Weight Shipped : 22,00

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

CERTIFICAT

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 835

POIDS EXPÉDIÉ / Weight Shipped : 22,00

Signature:

Date:

EXPÉDIÉ LE / Shipped On : 2015/03/04

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Rapport d'Inspection**Inspection Report**

BON DE TRAVAIL order	CHARGEMENT load
203060	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

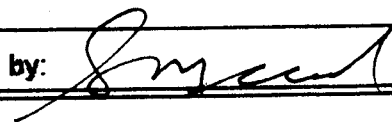
HAWKESBURY

ON K8A 1K7

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM																
27531		AL-6061																		
<u>SPÉCIFICATIONS DU PROCÉDÉ</u> processing specifications																				
SOL ANNEAL SINGLE AGING TO CONDITION T42																				
<table border="1"> <thead> <tr> <th>EXIGENCE / requirement</th> <th>SPÉCIFICATIONS / specified</th> <th>TESTS EXÉCUTÉS / performed</th> <th>RÉSULTATS DE TESTS / results</th> </tr> </thead> <tbody> <tr> <td>CONDUCTIVITY</td> <td>36 - 44 %IACS</td> <td>167</td> <td>37 - 39 %IACS</td> </tr> <tr> <td>HARDNESS</td> <td></td> <td>167</td> <td>67 - 69,5 HREW</td> </tr> <tr> <td colspan="4" style="text-align: right;">DURETE MESUREE EN HR15TW = 66,3-67,5 HR15TW</td> </tr> </tbody> </table>					EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results	CONDUCTIVITY	36 - 44 %IACS	167	37 - 39 %IACS	HARDNESS		167	67 - 69,5 HREW	DURETE MESUREE EN HR15TW = 66,3-67,5 HR15TW			
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HARDNESS		167	67 - 69,5 HREW																	
DURETE MESUREE EN HR15TW = 66,3-67,5 HR15TW																				
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description																		
835	22	D4202-1 (415) D4202-1 SPACER 129565 (420) D4720-1 129566 2 BOITE DE CARTON																		

COMMENTAIRES / comments

APPROUVÉ par / Approved by:



DATE: 2015-03-04

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
203060	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
27531		AL-6061		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications				
SOL ANNEAL SINGLE AGING TO CONDITION T42				
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results	
CONDUCT	36 - 44 %IACS	167	37 - 39 %IACS	
		60 KHZ		
HARDNESS		167	67 - 69.5 HREW	
			DURETE MESUREE EN HR15TW = 66,3-67,5 HR15TW	
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
835	22	D4202-1 (415) D4202-1 SPACER 129565 (420) D4720-1 129566 2 BOITE DE CARTON		

COMMENTAIRES / comments

SOL ANNEAL 529C, 35MIN
AGE HARDEN AMBIANT 96HRS

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification. All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée. Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

Vincent Carstén



MAR 05 2015